

Work Order ID 83241

83241

Page 1

Monday, April 16, 2012 10:45:37 AM

Item ID: D4212-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: 429 Clamp Cushion

Stop ***NS2***

Start Date: 4/16/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 4/20/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: *MF*

Date: *2-04-16*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4212

C

100

0.00

100

Mill Conv

Conventional Milling Machine

Memo

1-Turn as per folio FA974 & dwg

FOLIO REV: _____

DWG REV: _____

2-Deburr as required

Manual

0.00

12-4-25

12

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

12-4-25

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83241***83241***

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Cust Item ID:

Required Date: 4/20/2012 Req'd Qty: 10.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

SL 12-04-25

120

QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location **ST-459**

0.00

130

Packaging

Memo

0.00

Packaging

12x

SP

12-04-27

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/4/30 **JD**

12-04-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 83241
Parent Item: D4212-1
Parent Item Name: 429 Clamp Cushion

Start Date: 4/16/2012
Start Qty: 10.00
Required Date: 4/20/2012
Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 10-09-29 JLM VERIFIED BY:DD
DWG REV.C DD VERF:EC
IPP REV:B 11.01.10 AS PER

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4287-1		Manufactured	No			100	f	3.0830	0.3708	3.9031579			
UHMW U-Channel													

Location	Loc Qty	Loc Code
MAT055	1	
63828	1	
MAT056	2.083	
81713	2.083	

83243

4.0 ~~90~~ 12-4-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Dart Aerospace Ltd

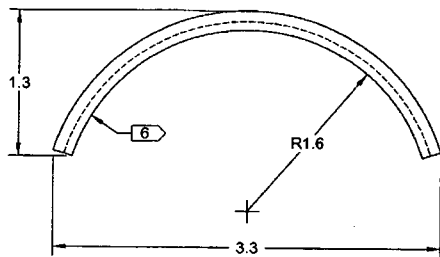
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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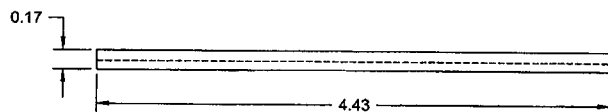
D4212-1 CLAMP CUSHION
(MAKE FROM D4212-1F)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

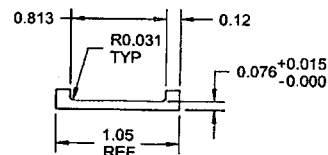
NO. ~~01333~~



83241



D4212-1F FLAT MACHINED STATE



RELEASED
2010-12-23

- NOTES:
- 1) MATERIAL: MAKE FROM D4287-1
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4212-1" AND B/N "BXXXXX" PER QSI 044 6.1
 - 7) WEIGHT: 0.02 lbs

C	ADDED FLAT MACHINED STATE: CHANGED DIMENSIONS (AW MANUFACTURING PROCESS: REF: PAR10-29)	MB	10.12.07
B	REDESIGN TO REDUCE COST: "CLAMP CUSHION" WAS "429 CLAMP CUSHION"; MAT'L WAS MUHMMWTR3.500W.XXXX (ZN A7-1)	MB	10.10.26
A	NEW ISSUE	MB	10.09.29
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.12.07		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4212** REV. C
SHEET 1 OF 1
TITLE **CLAMP CUSHION** SCALE NTS

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